



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

20NR-72

Job Sheet 200484



Part No: 20NR-72

Job Qty: 6 pcs

Part Name: Light Release Pivot Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/11/19

Job Tracking No:

Due Date: 11/27/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG 20NR-72 Rev. 1A IPP Rev. A 18.06.15 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Conventional Lathe - 1	6 pcs	11/27/19		0.00	0.60	Conventional Lathe - 1	11/19/12/15
							Conventional Lathe - 2	
120	QC 2	6 pcs	11/27/19		0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	



Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S237584



Part: 20NR-72

Job No: 200484

Serial No/Batch: S237584

Revision: 1A

Inspector:

Exp Date:

Instructions:

Date: 12/05/19

Plex 9/11/19 3:42 PM Dart.Renwick.Jennifer

9/11/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

130 QC 8	6 pcs	11/27/19	0.00 0.00	QC 2 - 63	N/19/12/5
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
150 Outsource - 15 - Nickel Plate	6 pcs	11/27/19	0.00 0.00	QC 8 - 8	
				QC 8 - 9	
160 Packaging 2-1 - Receive - B4B	6 pcs	11/27/19	0.00 0.00	QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	JAN 09 2020
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				GRO002-VC	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	

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				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	6 pcs	11/27/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	JAN 13 2020 68
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	6 pcs	11/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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				Packaging 3 - 32 - B4B.	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	6 pcs	11/27/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-50

Part Op 110 - (Manufacture as per dwg) 1-Machine as per DWG. 2-Deburr
Descriptions: **120** - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
150 - (Outside Processing - Nickel Plate)—Issue P/O; 45482 -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required
160 - (Receive & Inspect for Damage & Mat'l Certs)
170 - QC6- All purchased or subcontracted products
180 - (Identify as per dwg & Stock Location: _____) Bag and label with batch number.
190 - (QC21- Final Inspection - Work Order Release)

JAN 14 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140-R0.500	4140 Steel Round Bar 0.500"	.5940 ft (.099 ea)	110-Conventional Lathe - 1	S052587

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Conventional Lathe - 1	MT-4140-R0.500	1	19	0

Part Specifications
Specifications could not be found.

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Tel (613) 632-5200

PURCHASE ORDER **POHB045482**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045482

PO Date: 12/31/19

Due Date: 1/10/20

Purchase Order

Revision:

Revision Date:

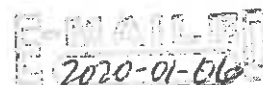
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
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PURCHASE ORDER

POHB045482



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200484	20NR-72	20NR-72 Rev 1A	Light Release Pivot Bushing (Outside Processing - Nickel Plate)-Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	1/10/20	6 pcs	0 pcs	6 pcs	\$11.6307/pcs	\$69.78

x6

JAN 09 2020

68
9-89

C



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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	204523	C45-44A	C45 Rev 20	C45 Load Beam Assembly Outsource15 (Outside Processing - Nickel Plate) -Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	1/10/20	1 pcs	0 pcs	1 pcs	\$33.7307/pcs	\$33.73

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PURCHASE ORDER

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Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	198337	C3-4-4A	C3-4-4A/C3-4-4KA Rev 10	C3 Load Beam Assy (Outside Processing - Nickel Plate) -Issue P/O -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed X6	-	1/10/20	6 pcs	0 pcs	6 pcs	\$44.6407/pcs	\$267.84
JAN 09 2020												
Grand Total:												\$371.36

JAN 09 2020

Guerrin



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PURCHASE ORDER

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Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an Integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/6/20 9:38 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(025204-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

025204 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
08-Jan-2020		Jigar Patel		POHB045482				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	A venir / Back Order
1	Z0NR-72 Rev.	Z0NR-72 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL STEEL CH	6	6	0	0	0
2	C45-4-4A Rev.	C45-4-4A E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733, TYPE 4 / 5, SC0 - SC4 0.0009 " OR MIL-C-26074, CLASS 1 / 2 BAKE AFTER [REFER TO THE DRAWING]	E-NICKEL ALUM CH	1	1	0	0	0
3	C3-4-4A Rev.	C3-4-4A - E-NIC STEEL 200 [E-NICKEL STEEL 200] NICKLE PLATE, QQ-N-290 CLASS 2, GRADE C NICKLE PLATE .0009-.0011 BAKE AFTER PLATING	E-NICKEL ALUM CH	6	6	0	0	0
4	BAKE Rev.	BAKE 01 -BAKING, HYDROGEN EMBRITTLEMENT RELIEF	BAKE MIN-CHG	1	1	0	0	0

RECEIVED
JAN 08 2020
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.